

D6101-003



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2667-2

Job Sheet 214971



Part No: D2667-2

Job Qty: 4 pcs

Part Name: Saddle, RH, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/3/20

Job Tracking No:

Due Date: 12/4/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	4 pcs	12/3/20		0.00	0.00	HAAS - 1	DAS 52 30/11/08	
							HAAS - 2	9-89	
							HAAS - 3		
							HAAS - 4	DAS	
100	HAAS 4 Axis - B4B	4 pcs	12/3/20		1.00	10.64	HAAS - 1 - B4B	DAS 52 20/11/09	
							HAAS - 2 - B4B	9-89	
							HAAS - 3 - B4B		
							HAAS - 4 - B4B	DAS	
110	Conventional Mill - 1 - B4B	4 pcs	12/3/20		0.00	10.64	Conventional Mill - 1 - B4B	DAS 52 20/11/09	
							Conventional Mill - 2 - B4B	9-89	
120	QC 2	4	12/3/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		



Container No: S311556



Part: D2667 - 2
Job No: 214971
Serial No/Batch: S311556
Revision: D
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
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Container No: S311556



Part: D2667-2

Job No: 214971

Serial No/Batch: S311556

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Da

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					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	DAS
					QC 2 - 57	52 20/11/09
					QC 2 - 62	9-89
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
130	QC 8	4	12/3/20	0.00 0.00	QC 8 - 12	
	pcs				QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
140	Handfinish - 1-1 Chemical-B4B	4	12/3/20	0.00 0.33	Handfinish - 1 - 1 - B4B	
	pcs				Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	

						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)- B4B	4 pcs	12/4/20	0.00	0.14	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
						Powdercoat - 5 - B4B	
						Powdercoat - 6 - B4B	
						Powdercoat - 7 - B4B	
						Powdercoat - 8 - B4B	
						Powdercoat - 9 - B4B	
						Powdercoat - 10 - B4B	
160	QC 3	4 pcs	12/4/20	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						QC 3 - 82	
						QC 3 - 87	
						QC 3 - 47	
170	Packaging 3-1 - Stock - B4B	4	12/4/20	0.00	0.00	Packaging 3 - 1 - B4B	

2020/11/27

20-11-30

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START: 11:35.

N.T. 300'

FINISH: 12:05.

DAS
NOV 30 2020 40
9-89

pcs				Packaging 3 - 2 - B4B		DAS
				Packaging 3 - 3 - B4B ✓	DEC 01 2020	80
				Packaging 3 - 4 - B4B	57394	9-89
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
180 QC 21 - SA	4 pcs	12/4/20	0.00 0.00	QC 21 - SA - 21	DAS	DEC 01 2020
				QC 21 - SA - 70	21	
				QC 21 - SA - 9	9-89	
				QC 21 - SA - 77		
				QC 21 - SA - 28		
Part Op 100 - 1-Machine as per folio F <u>4428</u> FOLIO REV: <u>AA</u> DWG REV: <u>D</u> 2-Debur Descriptions: 110 - (Manufacture as per dwg) 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: 180 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D6101-003	Saddle Billet, 7075	4 pcs (1 ea)	90-Machining - Issue SN	5296733		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
90-Machining - Issue SN	D6101-003	4	11	0		
Part Specifications						
Specifications could not be found.						

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DART AEROSPACE LTD		Work Order: 214971
Description: 206 Saddle, Outboard, Right side		Part Number: D2667-2
Inspection Dwg: D2667	Rev: D	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.124	0.124	0.125	0.125	
B	0.100	0.140		0.125	0.125	0.125	0.124	
C	1.125	1.145		1.135	1.135	1.135	1.135	
D	0.615	0.685		0.680	0.680	0.680	0.680	
E	0.240	0.260		0.254	0.254	0.252	0.251	
F	1.313	1.343		1.326	1.326	1.325	1.325	
G	0.210	0.230		0.222	0.222	0.222	0.222	
H	0.100	0.180		0.140	0.140	0.140	0.140	
I	2.470	2.510		2.492	2.432	2.432	2.432	
J	1.565	1.585		1.575	1.575	1.575	1.575	
K	0.235	0.240		0.238	0.238	0.238	0.238	
L	0.100	0.120		0.113	0.113	0.113	0.113	
M	0.990	1.010		1.004	1.005	1.004	1.004	
N	0.510	0.515		0.512	0.512	0.512	0.512	
O	5.990	6.010		6.002	6.002	6.002	6.002	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.312	0.318		0.313	0.313	0.313	0.313	
S	0.315	0.322		0.316	0.316	0.316	0.316	
T	1.995	2.005		2.000	2.001	2.000	2.000	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.787	0.807		0.797	0.796	0.796	0.797	
W	1.040	1.060		1.050	1.049	1.050	1.051	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.256	0.262		0.258	0.258	0.258	0.258	
Z	0.912	0.932		0.922	0.921	0.922	0.921	
AA	0.490	0.510		0.499	0.500	0.500	0.500	
AB	0.178	0.198		0.188	0.188	0.188	0.188	
AC								
AD								
AE								

DAS Accept/Reject

Measured by: 52	Date: 30/11/09
Audited by: [Signature]	Date: 30/11/22
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Revised dimensions R and Y	KJ	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					